

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube <input type="checkbox"/></td> <td style="width:15%;">Crosstube <input type="checkbox"/></td> <td style="width:15%;">Water Jet <input type="checkbox"/></td> <td style="width:15%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
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Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Work Order ID 111175

January-09-14 12:38:09 PM

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Page 2

Item ID: D4635-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fwd Ceiling Panel Assembly, RH
 Start Date: 09/01/2014 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 24/01/2014 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC - Inspect dimensions to drawing <i>5.</i>	0.00 DAS 27 9-89 14/1/23				1 Inspect as per Dwg PE1			
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00							
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

POSITIVE RECALL
 EFFECTIVE 14/01/22 AUTH
 RELEASED 8 DATE 14/01/24

Release Dwg as per Rev E
 DAS 27 9-89
 14/1/23
 MCF 14-1-23

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FAULT CATEGORY

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Picklist Print

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Page 1

Work Order ID: 111175

Parent Item: D4635-042

Parent Item Name: Fwd Ceiling Panel Assembly, RH

Start Date: 1/9/2014

Required Date: 1/24/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev. A 12/08/09 New Issue DL
DL IPP Rev C Dwg. Update 13/07/09 DL verf:DD
Rev D Dwg. Update 14/01/20 DL IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS24693-BB50 SCREW BB51		Purchased	No				Each	100.0000		8			Sh 14/01/23
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST300	124704	100							
				m127924		100							
D4635-142 Fwd Ceiling Replacement Panel Assembly, RH		Manufactured	No			100	Each	1.0000	1	1			Sh 14/01/23
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				prelim		1							
				111201		1							
D4646-1 Plenum Cap Assembly		Manufactured	No			100	Each	84.0000	2	2			Sh 14/01/23
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST116		84							
				103832		66							
				92968		6							
				95779		12							
D4652-1 Air Valve, 1.16 Id Disk Type		Manufactured	No			100	Each	203.0000	2	2			Sh 14/01/23
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				prelim		12							
				111316	111317	12							
				ST099		191							
				111311		191							

Picklist Print

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Page 2

Work Order ID: 111175

Parent Item: D4635-042

Parent Item Name: Fwd Ceiling Panel Assembly, RH

Start Date: 1/9/2014

Required Date: 1/24/2014

Start Qty: 1.00

Required Qty: 1.00

D4655-1
Speaker

Manufactured No

100 Each 90.0000

2 2

Location Loc Qty Loc Code

ST478 48

103939 48

ST483 42

93061 42

D4708-9

Lanyard

Manufactured No

100 Each 55.0000

2 2

Location Loc Qty Loc Code

ST119 55

111242 49

93919 6

D4728-042

RH Cabin Speaker #1

Manufactured No

100 Each 0.0000

1 1

D4728-044

RH Cabin Speaker #2

Manufactured No

100 Each 1.0000

1 1

Location Loc Qty Loc Code

ST121 1

96225 1

D4743-1

Speaker Grill

Manufactured No

100 Each 30.0000

2 2

Location Loc Qty Loc Code

ST122 30

111220 30

MS21044-N08

Nut

Purchased No

100 Each 265.0000

8 8

Location Loc Qty Loc Code

ST315 265

123741 115

m127813 150

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Shop Packet Print

Page 2

Picklist Print

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Page 3

Work Order ID: 111175

Parent Item: D4635-042

Parent Item Name: Fwd Ceiling Panel Assembly, RH

Start Date: 1/9/2014

Required Date: 1/24/2014

Start Qty: 1.00

Required Qty: 1.00

MS21919-WDG8

Purchased

No

100

Each

82.0000

6

6

Clamp

Location

Loc Qty

Loc Code

ST322

82

m127305

12

m127831

40

m127916

30

NAS1149DN832J

Purchased

No

100

Each

3,348.0000

8

8

Washer

Location

Loc Qty

Loc Code

ST293

1000

M127813

1000

st510

376

124555

376

ST510a

1972

M126319

972

M127255

1000

Y
14/01/23

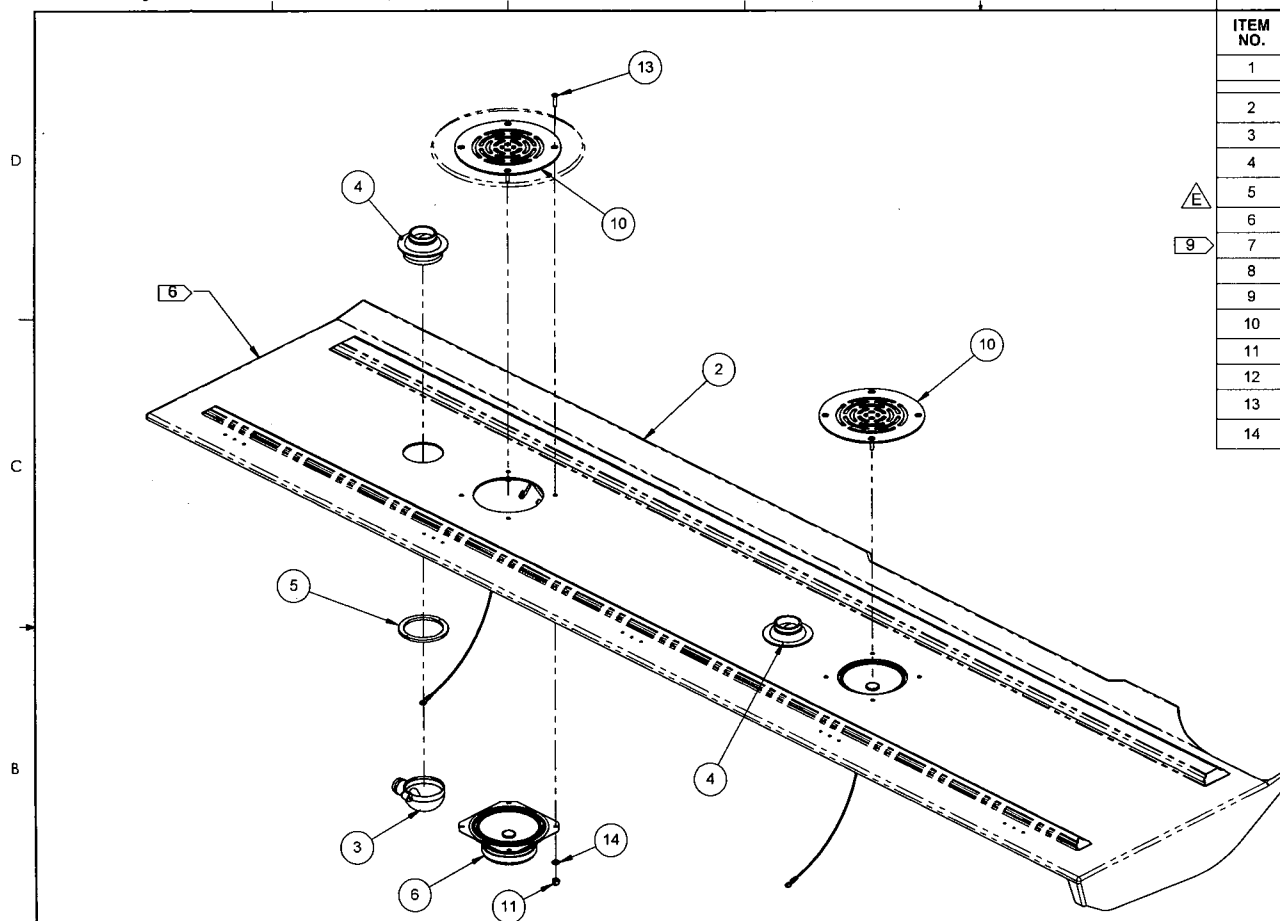
Stk
14/01/23

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Shop Packet Print

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8 7 6 5 4 3 2 1



ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	X	D4635-042	RH, FWD CEILING PANEL ASSY
2	1	D4635-142 ✓	RH, FWD CEILING REPLACEMENT PANEL ASSY
3	2	D4646-1 ✓	PLENUM CAP ASSEMBLY
4	2	D4652-1 ✓	AIR VALVE
5	2	D4652-3 (REF)	MOUNTING NUT (PART OF D4652-1)
6	2	D4655-1 ✓	SPEAKER
7	2	D4708-9 ✓	LANYARD
8	1	D4728-042 ✓	RH SPEAKER #1 HARNESS ASSEMBLY
9	1	D4728-044 ✓	RH SPEAKER #2 HARNESS ASSEMBLY
10	2	D4743-1 ✓	SPEAKER GRILL
11	8	MS21044-N08 ✓	NUT
12	6	MS21919WDC8 ✓	CLAMP
13	8	MS24693-BB50 ✓	SCREW
14	8	NAS1149DN832J ✓	WASHER

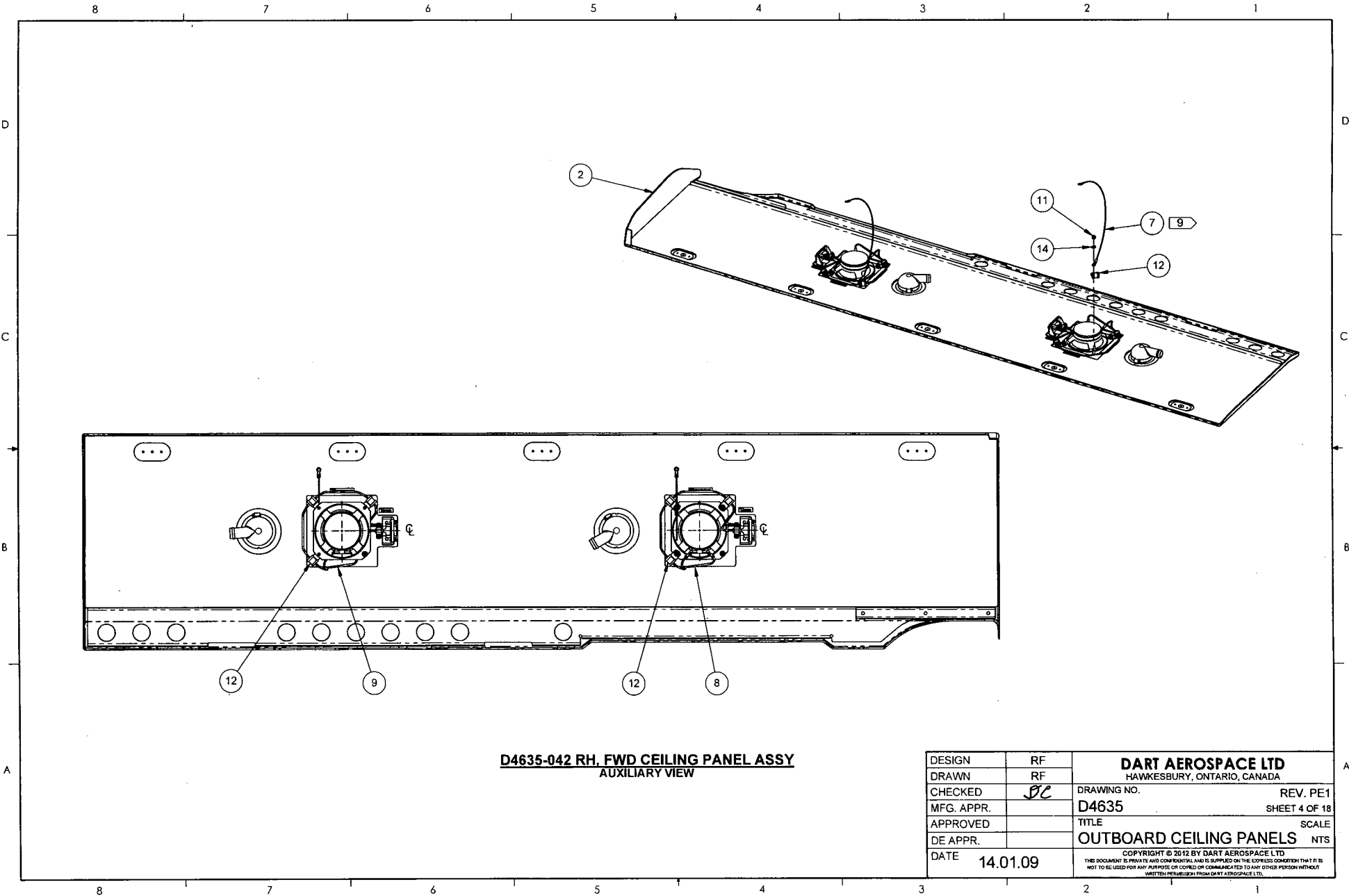
D4635-042 RH, FWD CEILING PANEL ASSY

NOTES:

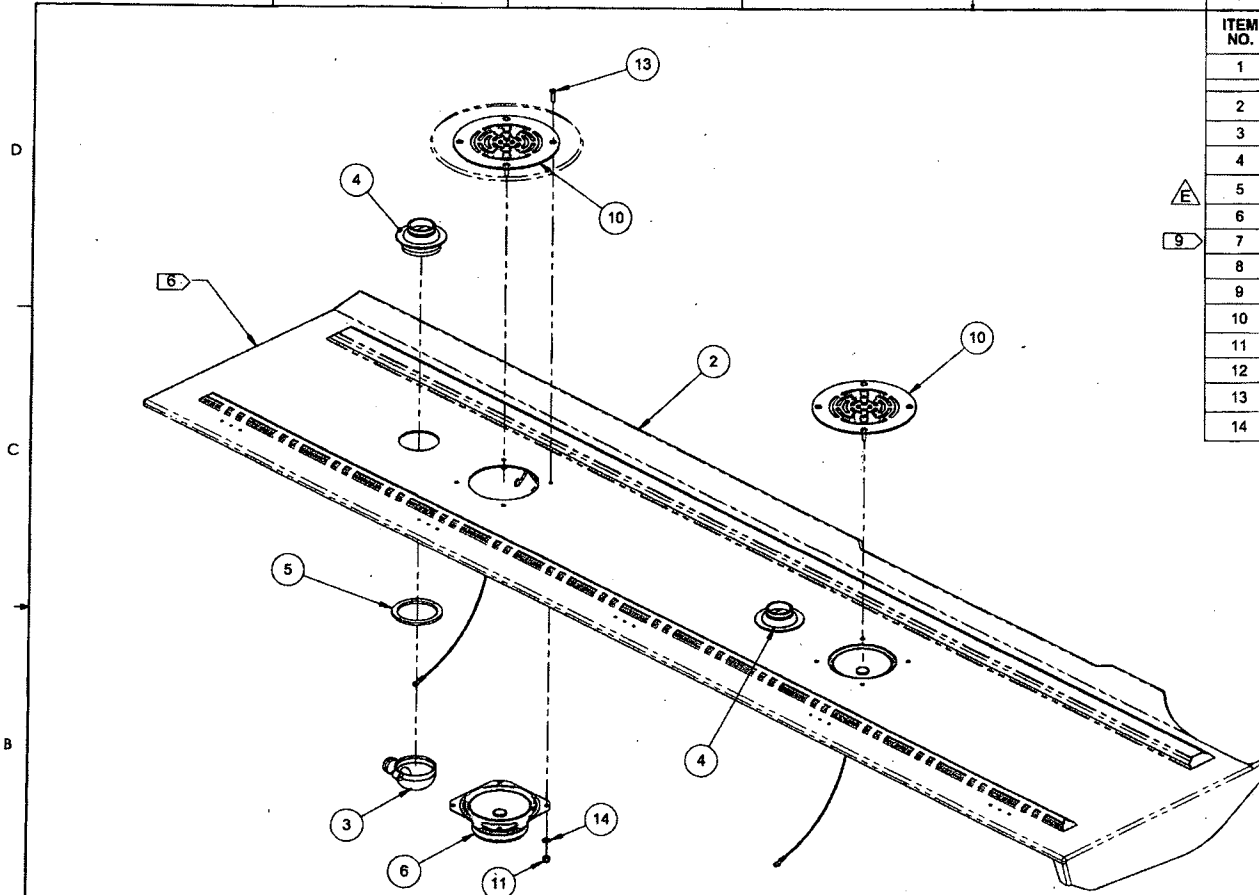
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4, ON SMOOTH SIDE
- 7) WEIGHT: 7.65 lbs
- 8) INSTALL D4728-042/-044 WIRE HARNESS PER QSI 048
- 9) ON D4708-9 LANYARD OPEN TO Ø0.196 BOTH ENDS

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	PC	DRAWING NO. D4635
MFG. APPR.		REV. PE1
APPROVED		SHEET 3 OF 18
DE APPR.		TITLE OUTBOARD CEILING PANELS
DATE	14.01.09	SCALE NTS
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8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1



ITEM NO.	QTY. -042	PART NUMBER	DESCRIPTION
1	X	D4635-042	RH, FWD CEILING PANEL ASSY
2	1	D4635-142	RH, FWD CEILING REPLACEMENT PANEL ASSY
3	2	D4646-1	PLENUM CAP ASSEMBLY
4	2	D4652-1	AIR VALVE
5	2	D4652-3 (REF)	MOUNTING NUT (PART OF D4652-1)
6	2	D4655-1	SPEAKER
7	2	D4708-9	LANYARD
8	1	D4728-042	RH SPEAKER #1 HARNESS ASSEMBLY
9	1	D4728-044	RH SPEAKER #2 HARNESS ASSEMBLY
10	2	D4743-1	SPEAKER GRILL
11	8	MS21044-N08	NUT
12	6	MS21919WDG8	CLAMP
13	8	MS24693-BB51	SCREW
14	8	NAS1149DN832J	WASHER

D4635-042 RH, FWD CEILING PANEL ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
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DRAWN	RF		
CHECKED	PC	DRAWING NO.	SHEET 3 OF 18
MFG. APPR.	PC	D4635	SCALE
APPROVED	PC	TITLE	NTS
DE APPR.	PC	OUTBOARD CEILING PANELS	
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8 7 6 5 4 3 2 1

